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Larger sheets were cut to proper size on this ream trimmer and then bundled and shipped to trade.

## CZ Bag Section Converts Over 50,000 Tons of Paper Annually

Two former separate departments devoted to manufacture of bags and printing of bags and paper were drawn together under common supervision in about 1963. Currently, the department head is Jim Buttenick.

An important part of a fully integrated paper and paper product manufacturing organization such as the Camas Division of Crown Zellerbach is the manufacture of a full range of the various styles of paper bags. The bag section converts more than 50,000 tons of Camas paper annually.

Although the everyday use of paper bags for a wide variety of purposes is commonplace today, the first machine-made paper bags were produced in as

late as 1860. Crown Zellerbach's first bags were produced in San Francisco during the 1890's. Those first machines were later moved to Camas in about 1906. Since that time, many changes in machinery and methods have taken place. Production rates have increased from a few thousand bags per day to the modern machine's production of more than a million flat bags in one, eight-hour period.

All of the four styles of bags in common use today are manufactured at Camas from a wide variety of paper grades, colors, and basis weights. Approximately 3,000 individual bag manufacturing specifications are now current. Many of these specifications cover specialty bags made for

individual customers for specific packaging use. However, a full range of so-called standard grocery bags, carry sacks and merchandise bags are made for general sale as stock items.

In order to manufacture this volume and range of bag sizes and styles, the bag section is equipped with 53 primary bag making machines, 8 secondary machines, 40 in-line flexographic printing presses or imprinters and many pieces of subsidiary equipment.

The ever-increasing demand is for specialty bags made from a widening variety of specially treated papers: Waxed, resined, plastic film coated, plastic and foil laminated. This has increased the variety of

adhesives required. Although a small portion of the special adhesives purchased is in ready-to-use form, approximately 99% of the 60,000 gallons of adhesive used monthly at Camas is mixed in a modern paste room from purchased dry materials.

Printing at Camas is essentially on materials used for packaging and wrapping paper products. Creative printing on bags and wrap enhances the saleability of paper products, but methods require constant change and refinement.

Many kinds of presses are made today, and the printing section at Camas has several varieties in various sizes. There are platen, flatbed, duplex, rotary, flexographic,

self-feeding and multicolor presses.

A recent development in fruit tissue printing is a printer sleeter. This is a two-color press with a slitter cutting attachment called a "sleeter". This enables the printing, slitting, cutting and automatic jogging of tissue into regular fruit tissue wrap sizes in a single operation.

The fastest growing volume of printing is in the bag section. The demand for printed bags over plain bags has caused a steady increase in the printing capacity in this area.

Although the number of people employed in the bag-print department varies with the order situation, the number would normally be around 400.

## Bag Factory Gals Get New Lunchroom

(From "Makin' Paper", Jan. 1919).

A new lunch room has been installed for the accommodation of the girls in the bag factory.

The room is steam heated and is equipped with tables, numerous chairs, the necessary dishes, a coffee urn and tea pot. Moreover, a matron has been put in charge.

Hot drinks are served to the girls at the minimum cost of two cents per cup. And last, but not least, the company has contributed a \$5 working fund. Mr. Duvall (bag factory superintendent) was somewhat overcome with the size of the fund.

LaCamas townsite and millsite were platted and construction begun in 1883.